Work Order ID 91703

October-15-12 3:22:52 PM

91703

Item ID: D3188-2M **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: SPACEPOD BODY RH

Start Date: 10/15/12 **Start Qty:** 1.00 *1*

Required Date: 11/05/12 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3188	Rev F								
100		0.00							
100	PURCHASING								
Purchasing		0.00							
Purchasing	**Memo** Issue P/O: 18135 Description:D3188-2M BODY SHIP: QTY (8) D2213 Spacers Supplier: Delastek Conformity Certificate and Process sheet required Ship 2 Items from Previous steps								12-10-12
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging		0.00							
Packaging	**Memo** Ensure a copy of certification of conformity and process sheet from Delastek is attached.								12/12/12

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Item ID: D3188-2M **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: SPACEPOD BODY RH

Start Date: 10/15/12 **Start Qty:** 1.00 *1*
Required Date: 11/05/12 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	**Memo**	0.00							
Quality Control	Check for void spot and pins.								
130	Identify as per dwg & Stock Location: composites	0.00							
130									
Packaging	**Memo**	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	**Memo**	0.00							
Quality Control									

DAS 16 9-8-8 13/3/201

ST 13-03-01

13/3/4

MF 13-3-01

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Sk'd-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio

☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions

☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____

Picklist Print

October-15-12 3:22:51 PM

Work Order ID: 91703

Parent Item: D3188-2M **Start Date:** 10/15/12 **Required Date:** 11/05/12

Parent Item Name: SPACEPOD BODY RH **Start Qty:** 1.00 **Required Qty:** 1.00

Comments: IPP Rev:A New issue ecn882 06-11-30 EC
IPP rev B rev D dwg 07.03.07 ec
IPP rev C rev E dwg 07.04.16 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2213 Insert		Manufactured	No			100	Each	146.0000	8	8	8	B30809 12-10-16	
				Location		**Loc Qty**		**Loc Code**					
				ST006		146							
				30809		146							
D3188-2P Spacepod Body		Purchased	No			110	Each	0.0000	1	1	1	12/3/12 C	

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
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- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

GENERAL NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3188-1 = N/A
D3188-2 = N/A
D3188-3 = N/A
D3188-5 = N/A
D3188-6 = N/A
D3188-7 = N/A

8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

W/O 91703

RELEASED
2009 -10- 20

REV.	DESCRIPTION	BY	DATE
F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL/ FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 1 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	09.07.13		

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DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

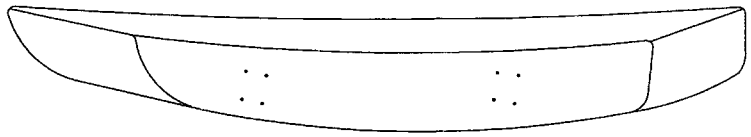
General

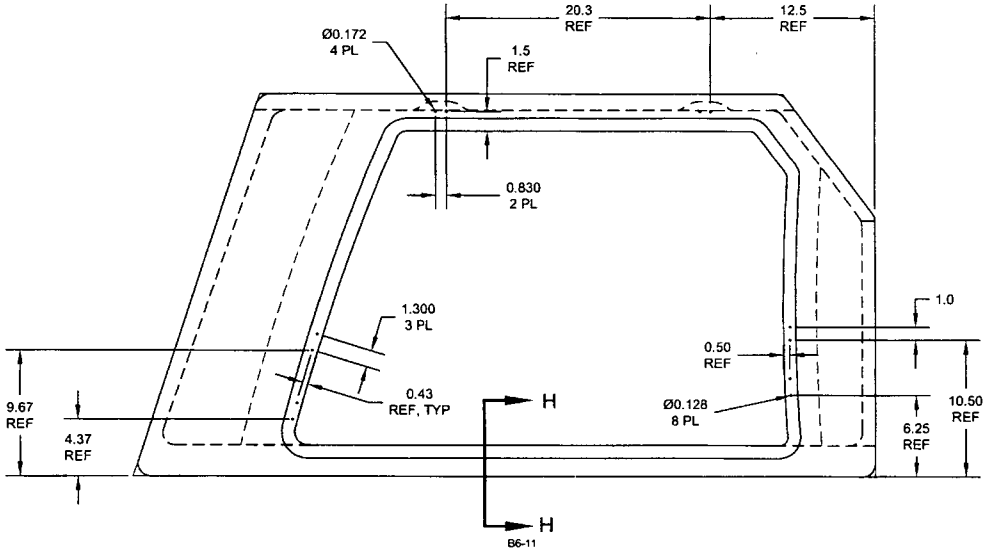
- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____





RELEASED
2009 -10- 20

D3188-1 SPACEPOD BODY
MAKE FROM D3188-1M

NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	JB	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 2 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	09.07.13		

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DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped.
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

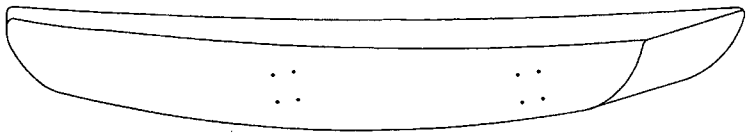
General

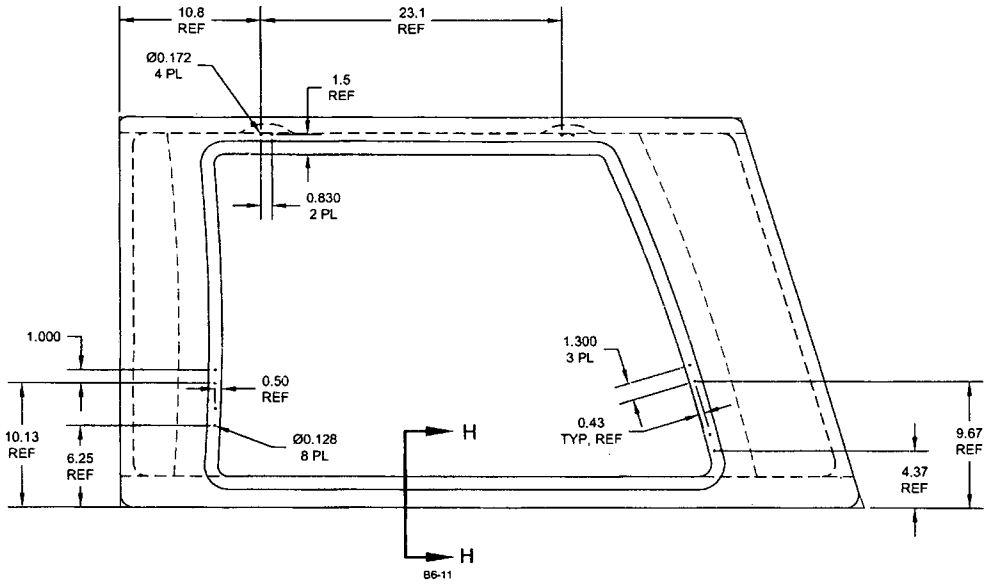
- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____





D3188-2 SPACEPOD BODY
MAKE FROM D3188-2M

RELEASED
2009 -10- 20

NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	JB	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. REV. F
MFG. APPR.		D3188 SHEET 3 OF 11
APPROVED		TITLE SCALE
DE APPR.		SPACEPOD BODY NTS
DATE 09.07.13		

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DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

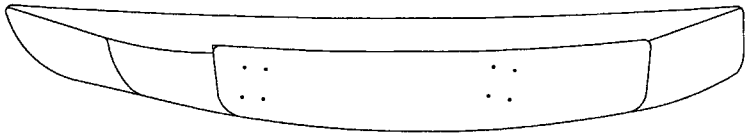
General

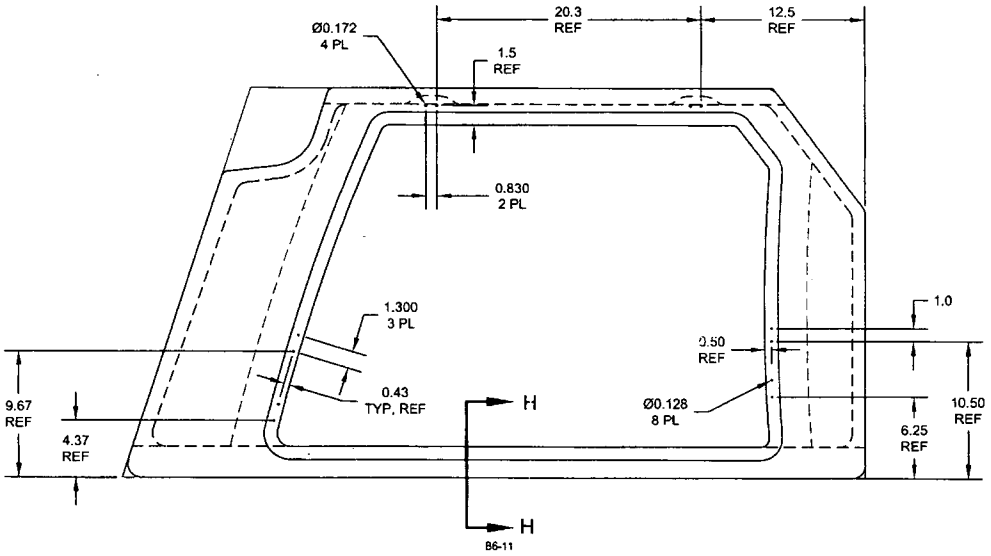
- ☐ Bend
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- ☐ Countersink
- ☐ Cut Too Short
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- ☐ Finish
- ☐ Folio
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- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____





D3188-3 SPACEPOD BODY
MAKE FROM D3188-3M

RELEASED
2009 -10- 20

NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	JB	**DART AEROSPACE LTD**	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	09.07.13		

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DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

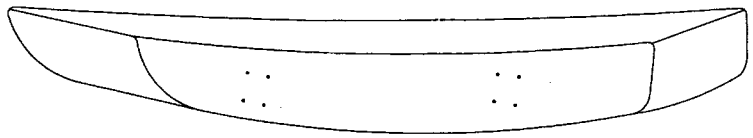
General

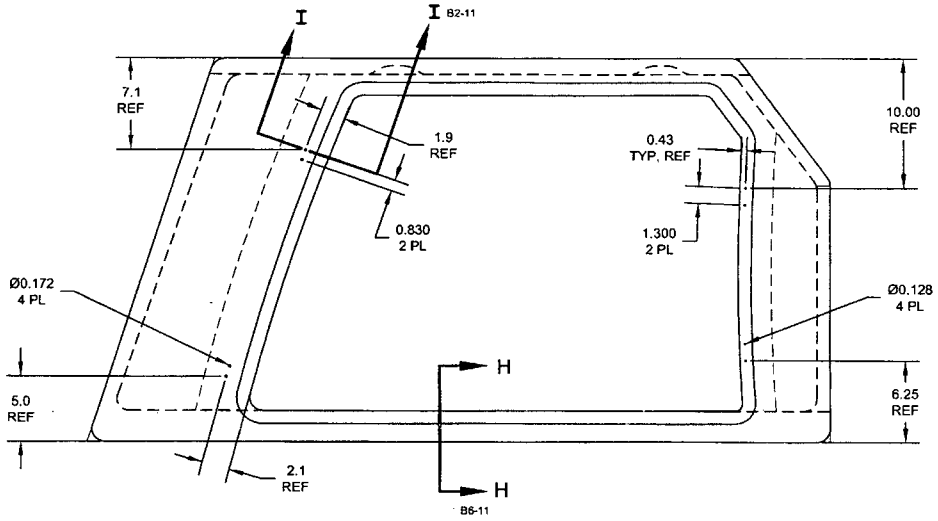
- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____





D3188-5 SPACEPOD BODY
MAKE FROM D3188-1M

RELEASED
2009 -10- 20

NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	09.07.13		

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DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped.
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

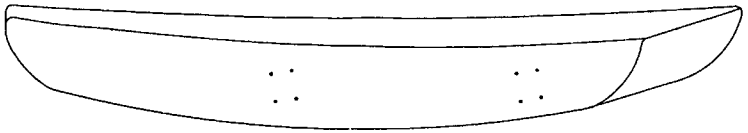
General

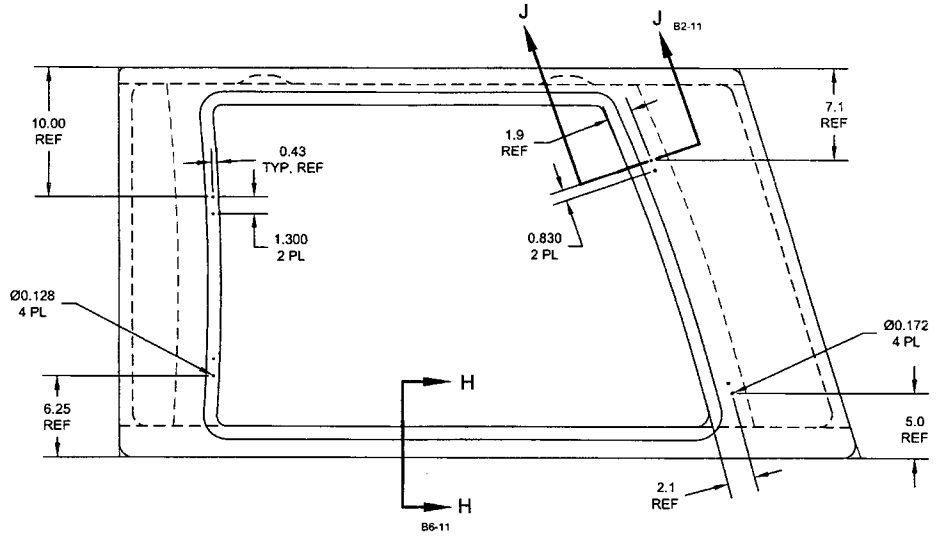
- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____





D3188-6 SPACEPOD BODY
MAKE FROM D3188-2M

RELEASED
2009 -10- 20

NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	09.07.13		

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DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

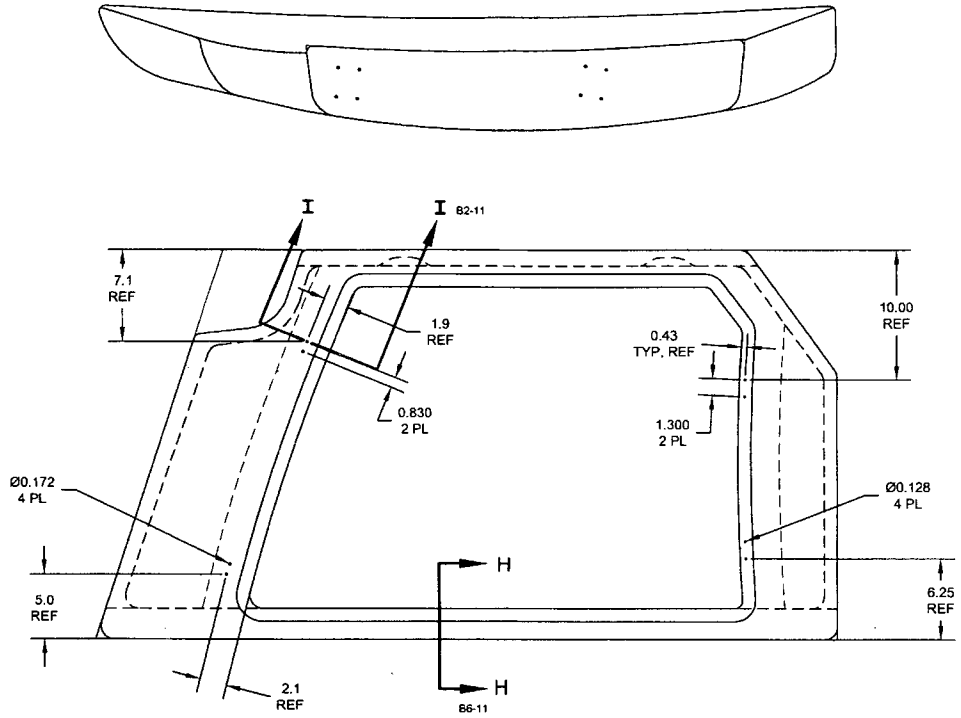
FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____



D3188-7 SPACEPOD BODY
MAKE FROM D3188-3M

RELEASED
2009 -10- 20

NOTE:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

DESIGN	JB	**DART AEROSPACE LTD**	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	09.07.13		

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DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio

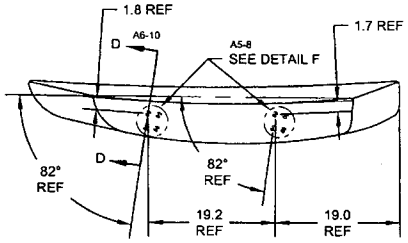
☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions

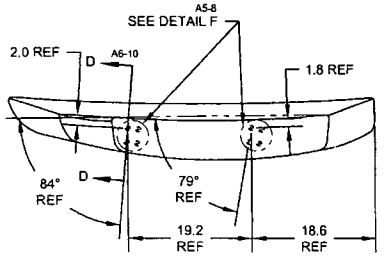
☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

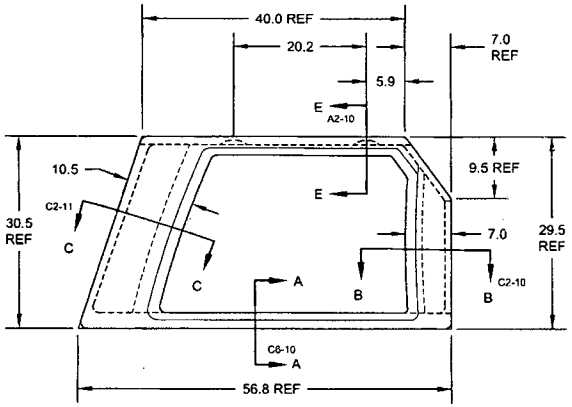
☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

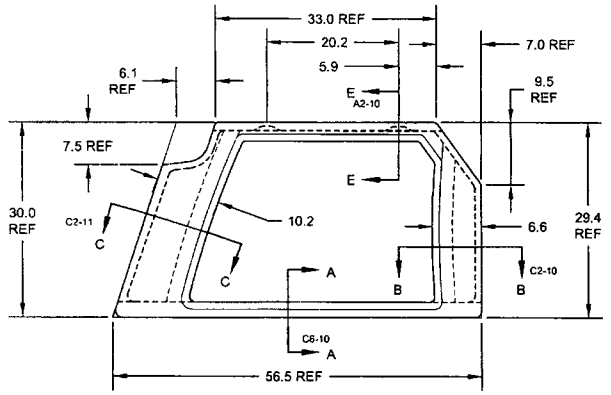
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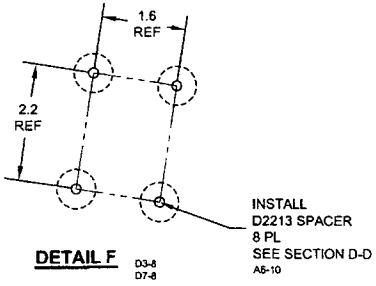




D3188-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY



DETAIL F D3-8 D7-8

RELEASED
2009 -10- 20

D3186-1M/-3M NOTES:
1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
2) SEE SHEET #10 FOR SECTION VIEWS.

DESIGN	JB	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 8 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	09.07.13		

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DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped.
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

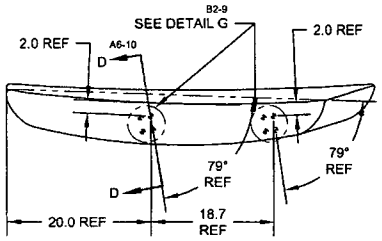
General

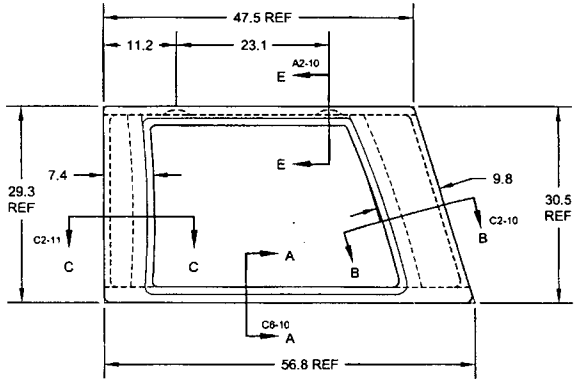
- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

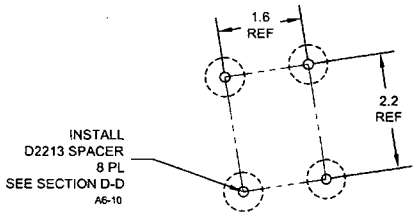
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D3188-2M SPACEPOD BODY



DETAIL G D6-9

RELEASED
2009 -10- 20

D3186-2M NOTES:
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
2) SEE SHEET #10 FOR SECTION VIEWS.

DESIGN	JB	**DART AEROSPACE LTD**	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 9 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	09.07.13		

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DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

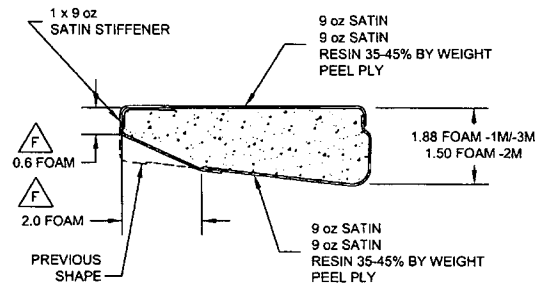
☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

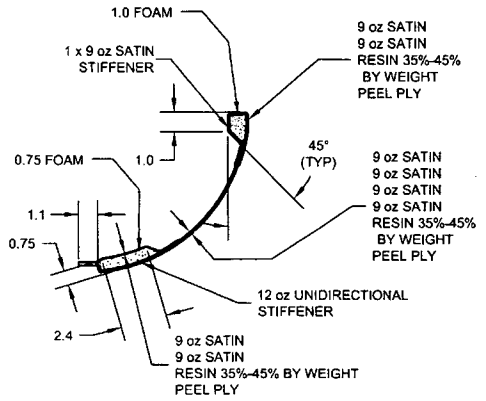
☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio
☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

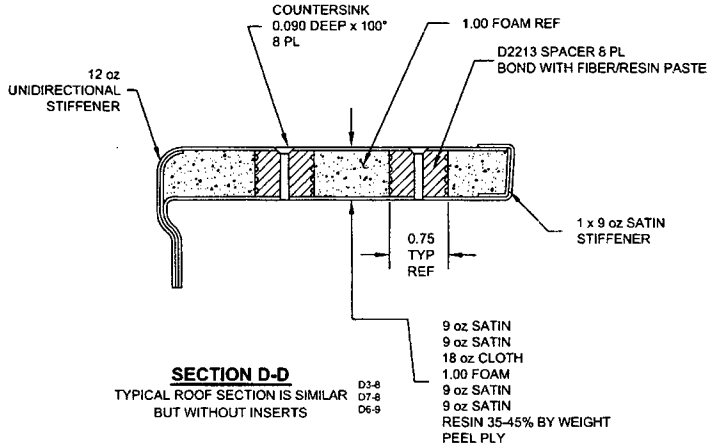
OUTBOARD



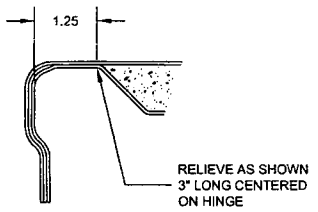
SECTION A-A B7-8 B3-8 B6-9
TYPICAL FLOOR SECTION



SECTION B-B B6-8 B8-8 B4-8 B2-8 B7-9 B5-9
SECTION C-C OPPOSITE



SECTION D-D D3-8 D7-8 D6-9
TYPICAL ROOF SECTION IS SIMILAR BUT WITHOUT INSERTS



SECTION E-E C2-8 C7-8 B6-9
2 PLACES PER POD

RELEASED
2009 -10- 2 1

DESIGN	JB	**DART AEROSPACE LTD**	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 10 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	09.07.13		

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DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio

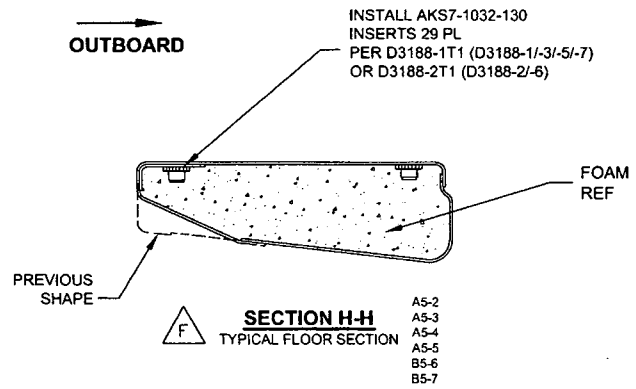
☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions

☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

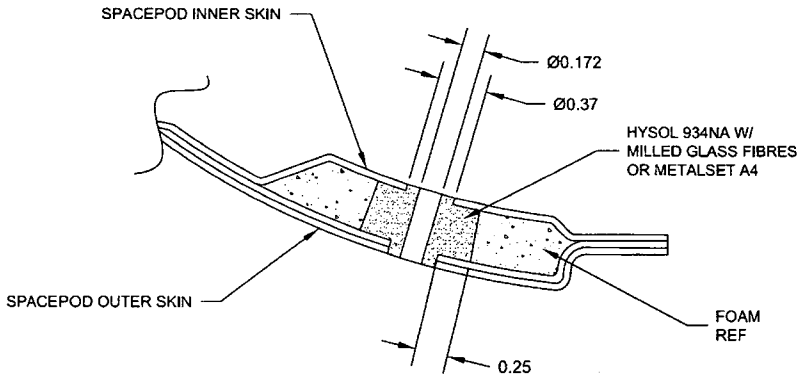
☐ Other

_____
_____
_____



F **SECTION H-H**
TYPICAL FLOOR SECTION

A5-2
A5-3
A5-4
A5-5
B5-6
B5-7



SECTION I-I
SECTION J-J OPPOSITE
4 PLACES PER POD

C5-5
C4-6
C5-7

RELEASED
2009 -10- 20

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 11 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	09.07.13		

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DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
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General

- ☐ Bend
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- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
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- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
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- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

DELASTEK Inc.
2699 5e Avenue
Local 14, C.P. 10100
Grand-Mère, Québec G9T 5K7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice No.	46755
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
06-02-2013	16-10-2012	21923	Brigitte Golden	PO18135	Net 30 days USA

Ship Via	F.O.B.	Salesperson	GST/PST
Day & Ross Collect	Origin	Mathieu Doucet, ext.690	

Order Qty	B.O. Qty	Current Ship.	Item number	Description
1	0	1	DKC134-0060	Line #2 N° D3186-2P Spacepod Door RH U of M: Chaque B91704 Dwg. D3186 Rév.: E Serial # Lot # B91704 45776
1	0	1	DKC134-0071	Line #3 N° D3188-2P, Spacepod Body RH U of M: Chaque B91703 Dwg. D3188 Rév.: F Serial # Lot # B91703 45779

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request

Accepted by:

DELASTEK QA-3

Quality department AQ-357

☑ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Mardi 2012-10-23 08:35:11
Utilisateur: marc dubé

Feuille de Procédé

Client	: DART US DART AEROSPACE	**Nom Dessin**	: SPACEPOD BODY RH
Numéro Job	: 45779	**Numéro Article**	: DKC134-0071
Numéro	: 3763	**Numéro Dessin**	: –
Numéro B.A.	:	**Projet Numéro**	: DK-362
Cette fois	: 2012-10-23 **No.** :	**Révision dessin**	:
Prsht Rev.	: NC	**Matériel**	: Fibre 7781 et résine 411-350
Prem. fois	: - - **Type** :	**Date Dûe**	: 2012-10-30 **Qté:** 1 **Ud** UNITE
Job précédente	: 45778		
Écrit par	:		
Vérifié & Approuvé par	:		
Commentaires	: N° de dessin: D3188-2M rev. F E.O.: N/A Feuille de Procédé Rév.: 06 AMB0349 remplacé par AMB0511 (réf. RFC #226) Formulaire d'inspection: N/A		

DELASTEK M-2

B 91703

Produit additionnel

Numéro Job:

# Séq.:	Machine ou	Description :
1.0	AAC1616	N° 83634, Frekote Loctite Wolo
Comment	Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s) N° 83634, Frekote Loctite Wolo	N° de Lot: 1-37420-1
2.0	PRÉPARATION	Préparation du moule
Comment	Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs Faire la préparation du moule selon IF134-0020. Date: 26/01/13 Sceau: DELASTEK COMPOSITES 65	
3.0	AAC1885	Tissu à délaminer Release ply B
Comment	Qty.: 9.84 VERGE(s)/Unit Total : 9.84 VERGE(s) Tissu à délaminer Release ply B	# de Lot: N/A
4.0	AAC1887	Wrightlon 5200 Bleu P3
Comment	Qty.: 9.27 VERGE(s)/Unit Total : 9.27 VERGE(s) Wrightlon 5200 Bleu P3	# de Lot: N/A
5.0	AC0885	Feutre de drainage N° Airweave N 10
Comment	Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)	

Date: Mardi, 2012-10-23 08:35:11
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE **Nom Dessin:** SPACEPOD BODY RH
Numéro Job: 45779 **Numéro** DKC134-0071

Numéro Job:

# Séq.:	Machine ou Opération:	Description :
6.0	AC0943	Stretchlon 200 poche à vide Vert
Comment	Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s)	
7.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
Comment	Qty.: 11.4 VERGE(s)/Unit Total : 11.4 VERGE(s) 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: 1-36539-2	
8.0	AMB0511	N° TG-13-U, Fiberglass 13 oz
Comment	Qty.: 0.80 VERGE(s)/Unit Total : 0.80 VERGE(s) N° TG-13-U, Fiberglass 13 oz N° de Lot: 1-36302-1	
9.0	AMB0213	WR1850 Roving 18oz. x 50"
Comment	Qty.: 0.350 KILOGRAMME(s)/Unit Total : 0.350 KILOGRAMME(s) WR1850 Roving 18oz. x 50" N° de Lot: 1-33539-1	
10.0	AC0886	Ruban à gommer jaune #: T/AT-200Y
Comment	Qty.: 4.0000 ROULEAU(s)/Unit Total : 4.0000 ROULEAU(s)	
11.0	PREP-GENERAL	Préparation du matériel
Comment	Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs Tailler les tissus selon IF134-0020 L.B. Date 24-oct 12 Sceau: 48 DELASTEK 59	
12.0	AMB0286	Catalyst N° DDM-9
Comment	Qty.: 0.0640 GALLON(s)/Unit Total : 0.0640 GALLON(s) Catalyst N° DDM-9 N° de Lot: 1-27829-1	
13.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
Comment	Qty.: 2.000 LITRE(s)/Unit Total : 2.000 LITRE(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-38897-1	
14.0	AAC1540	Fibre de verre Miapoxy 66
Comment	Qty.: 0.0040 GALLON(s)/Unit Total : 0.0040 GALLON(s) Fibre de verre Miapoxy 66 N° de Lot: 1-37956-1	
15.0	PREP-GENERAL	Préparation du matériel
Comment	Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs Laminer la 1ère coquille selon IF134-0020 Date 16/01/13 Sceau: DELASTEK COMPOSITES 65 DELASTEK 7 DELASTEK 30	

Form: rprocess

Date: Mardi, 2012-10-23 08:35:11
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	**Nom Dessin:**	SPACEPOD BODY RH
Numéro Job:	45779	**Numéro**	DKC134-0071

Numéro Job:

# Séq.:	Machine ou Opération:	Description :
16.0	AMB0355	ATC core-cell A500 plain 4'x8' 1" thick
Comment	Qty.: 0.750 FEUILLE(s)/Unit Total : 0.750 FEUILLE(s) ATC core-cell A500 plain 4'x8' 1" thick N° de Lot: 1-38256-1	
17.0	TAILLAGE	Faire le taillage du matériel
Comment	Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs Tailler et ajuster les Foam Core selon IF134-0020. Date: 21/01/13 Sceau: DELASTEK 1	
18.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
Comment	Qty.: 0.136 KILOGRAMME(s)/Unit Total : 0.136 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-39253-1	
19.0	AMB0286	Catalyst N° DDM-9
Comment	Qty.: 0.0096 GALLON(s)/Unit Total : 0.0096 GALLON(s) Catalyst N° DDM-9 N° de Lot: 1-27829-1	
20.0	FINITION	Finition Générale
Comment	Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs Sceller les foam core selon IF134-0020. Date: 21/01/13 Sceau: DELASTEK 1	
21.0	PERCAGE	Perçage de trous
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Percer les foam core selon IF134-0020. Date: 21/01/13 Sceau: DELASTEK 1	
22.0	AAC1611	Polybond B46F
Comment	Qty.: 0.078 KIT(s)/Unit Total : 0.078 KIT(s) Polybond B46F N° de Lot: 1-29934-1	
23.0	ASSEMBLAGE	Assemblage mécanique
Comment	Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs Installer les foam core selon IF134-0020.	

Form: rprocess

Date: Mardi, 2012-10-23 08:35:11
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	**Nom Dessin:**	SPACEPOD BODY RH
Numéro Job:	45779	**Numéro**	DKC134-0071

Numéro Job:

# Séq.:	Machine ou Opération:	Description :
	Date: 21/01/13 Sceau: 1	
24.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler
Comment	Qty.: 0.050 GALLON(s)/Unit Total : 0.050 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-39010-1	
25.0	FINITION	Finition Générale
Comment	Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs Usiner les foam core selon IF134-0020. Date: 23/01/13 Sceau: 1	
26.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
Comment	Qty.: 1.600 KILOGRAMME(s)/Unit Total : 1.600 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-39253-1	
27.0	AMB0286	Catalyst N° DDM-9
Comment	Qty.: 0.0536 GALLON(s)/Unit Total : 0.0536 GALLON(s) Catalyst N° DDM-9 N° de Lot: 1-27929-1	
28.0	LAMINAGE	Faire le laminage
Comment	Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs Laminer les plis de 9oz selon IF134-0020. Date: 23-1-2013 Sceau:	
29.0	TRIMAGE	Trimage
Comment	Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs Faire le taillage selon IF134-0022 Date: 24/1/13 Sceau:	
30.0	AMB0286	Catalyst N° DDM-9
Comment	Qty.: 0.0144 GALLON(s)/Unit Total : 0.0144 GALLON(s) Catalyst N° DDM-9 N° de Lot: 1-27929-1	
31.0	AAC1540	Fibre de verre Miapoxy 66
Comment	Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s) Fibre de verre Miapoxy 66 N° de Lot: 1-37956-1	

Form: rprocess

Date: Mardi, 2012-10-23 08:35:11
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE **Nom Dessin:** SPACEPOD BODY RH
Numéro Job: 45779 **Numéro** DKC134-0071

Numéro Job:

# Séq.:	Machine ou Opération:	Description :
32.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
Comment	Qty.: 0.450 KILOGRAMME(s)/Unit Total : 0.450 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-39253-1	
33.0	LAMINAGE	Faire le laminage
Comment	Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs Faire le laminage des derniers plis 9oz selon IF134-0020. Date: 24/01/13 Sceau: DELASTEK 32 DELASTEK 30 DELASTEK COMPOSITES 65	
34.0	AAC1610	Spacer N° D2213
Comment	Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) Spacer N° D2213 N° de Lot: 1-38200-1	
35.0	ASSEMBLAGE	Assemblage mécanique
Comment	Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs Faire l'assemblage des inserts selon IG 0097. Date: 28/01/13 Sceau: DELASTEK COMPOSITES 65	
36.0	AAC1021	Dupont Primer N° 7704S
Comment	Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s) Dupont Primer N° 7704S N° de Lot: 1-36493-1	
37.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase
Comment	Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-36256-3	
38.0	FINITION	Finition Générale
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Préparer la pièce selon IG 0008. Date: 29/01/13 Sceau: DELASTEK COMPOSITES 65 DELASTEK COMPOSITES 72	
39.0	PRIMER	Application primer
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Préparer et appliquer le primer selon IG 0008. Date: 29-01-13 Sceau: DELASTEK 57 # de fiche de mélange: N/A	

Form: rprocess

Date: Mardi, 2012-10-23 08:35:11
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	**Nom Dessin:**	SPACEPOD BODY RH
Numéro Job:	45779	**Numéro**	DKC134-0071

Numéro Job:

# Séq.:	Machine ou Opération:	Description :
40.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler
Comment	Qty.: 0.010 GALLON(s)/Unit Total : 0.010 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-39010-1	
41.0	FINITION	Finition Générale
Comment	Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs Faire les réparations de finition s'il y a lieu selon IG 0008. Date: 3/01/13 Sceau: DELASTEK COMPOSITES 65 DELASTEK 32	
42.0	AAC1021	Dupont Primer N° 7704S
Comment	Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s) Dupont Primer N° 7704S N° de Lot: 1-36423-1	
43.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase
Comment	Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-36356-3	
44.0	PRIMER	Application primer
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Préparer et appliquer le primer selon IG 0008. Date: 31-02-13 Sceau: DELASTEK 57 # de fiche de mélange: N/A	
45.0	INSPEC FINAL	Inspection finale
Comment	Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs Faire l'inspection générale de la pièce selon le dessin par le département de la qualité. Date: 5/02/13 Sceau: DELASTEK 04-2 Initiales: SB	
46.0	EMBAL / ENTREPO	Emballage & Entreposage
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire l'emballage selon IG 0057. Date: 6-2-13 Sceau: DELASTEK 58	

Form: rprocess